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Julv=12-13 10:04:36 AM

104497

Page 1

fitem ID: D3915-041 Accept *N900040100* Setup Start Revision ID: Stop Light Lid Assemby, Long Basket Item Name: Start Qty: 1.00 7/10/13 **Start Date: Cust Item ID:** Required Date: 7/12/13 Req'd Qty: 1.00 **Customer:** Reference: Start Run Date: 13-07-16 Tooling: Process Plan: MLブ Approvals: Date: Stop Date: SPC (Y/N): Date: Set Up/ Tool ID Tool # Plan Accept Reject Réject Sequence ID/ Operation , Insp. Number * Stamp Description Code Qty Work Center ID Qty **Run Hours Revision Nbr** Draw Nbr D3915 Weld per dwg A/R Aluminum rod Batch: 0.00_ 100 SAG Large Fab 4123928 13-11-27 *100* 0.00 Large Fab Memo 1- assemble ribs, weld as per dwg D3915 using DT9606A. When welding Large Fab D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915 DAS QC9-Inspect visual per QSI004-Fusion Welds 0.00 110 13-11-78 0.00 OC Memo Quality Control

DQA:		<u> </u>	Date:		WORK ORDER NON-CONFORMANCE / UPDATE							DART	
QA Closed:		1	Date:			WORK ORDER NON-		JINFOI		Work	Order up	odate only	AEROSPACE
Work Orde	٠r٠	· ı			·	DISPOSITION			AGAINST	DEPA	RTMENT	/PROCESS	
Part N	ا ا	······································				Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty	Desc	ription of work order update or non-conformance		initial nief Eng	Action Description	!	Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		!	4 OA					P Description Date Vernice					
							FAI	ULT CAT	TEGORY				
Landi		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple ot n Strip in natter	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Off-set Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge Off-set Out of Calibration					Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw		e		Fit/Function	\vdash	1	Sequence	_	*		

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID 104497 *104497* Page 2 July-12-13 10:04:36 AM Accept Item ID: D3915-041 *N900040100* Setup Start **Revision ID:** Light Lid Assemby, Long Basket Item Name: Start Qty: 1.00 7/10/13 **Start Date: Cust Item ID:** Req'd Qty: 1.00 Required Date: 7/12/13 **Customer:** Reference: Run Process Plan: Date: - Tooling: Date: **Approvals:** Stop QC: Date: **SPC (Y/N):** Date: Reject Reject Tool ID Tool # Plan Accept Insp. Operation Set Up/ Sequence ID/ Qty Number Stamp Code **Qty** Work Center ID **Run Hours Description** 0.00 120 QC5- Inspect part completeness to step on W/O *120* 9 D 13-11-98 0.00 Memo **Quality Control** Chemical Conversion Coat per QSI005 4.1 0.00 130 1 7613-11-28 *130* 0.00 HandFinish Memo ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE*** Hand Finishing

140

140

Large Fab

F . 18 /

Large Fab

Weld per dwg A/R Aluminum rod Batch:___

0.00

4123928

Memo

0.00

1- weld (4) corners

(ly)

045) 43)

13-11-08

DQA:		[Date: _				DART							
						WORK ORDER NON-	-CC	ONFO	RMANCE / U				_	AEROSPACE
QA Closed:		· [Date:		7		_			* .	W	ork Order up	date only	A
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	
vion ora						Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	10.					Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing		1	re/Packaging	Other
NCR N	No					Suspected Unapproved			Large Fab	Composite			Supplier	
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Root					Desci	ription of work order update		nitial		tion		Sign &		
Cause	Date	e S	tep	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
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Equip/Tooling Handling/Pre			l											·
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Process]	İ	:					3					
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Landi	ng Gear					General		•		_				
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	Cracks		• •			Broken/Damage/Defect	<u> </u>	Hardwa	re	1		Part Incorred	ct	Temperature/Cure
	Crimp,	/Kink/F	Ripple/	Wave	<u> </u>	Burrs		Inspection Incomplete/Unqualified				Part Lost/Mi	ssing	Weld
	Cuffs	•				Contamination		Instructions Incomplete/Unclear				Part Moved		Wrong Stock Pulled
	Crushi	_			-	Countersink	<u> </u>	1 *	ned/off center			Positioned V		٦
	Heat T		mina ina 7	Tulba	_	Cut Too Short	Mislabeled Power Loss/Surge					Surge	Other	
	Inspec Marks			iube	-	Drawing Drill Holes	Misread							
	Turnin				\vdash		H	Off-set	Calibratia -					
	Wave	-		Δ	-	Finish Fit/Function		ł	Calibration Sequence			····		
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July-12-13 10:04:36 AM

Item	ID:	

D3915-041

Accept

N900040100

Setup Start

Revision ID:

Item Name:

Light Lid Assemby, Long Basket

Start Date: 7/10/13 Required Date: 7/12/13

Start Oty: 1.00 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Tool ID

Réference:

~ * *	
⊸A nr	irovais:
1.1	rovals:

Process Plan:

Date:

Tooling:

Date:

Run

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Tool # Plan

Code

Stop

Reject

Number

Sequence ID/ Work Center ID 15Ó

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Run Hours 0.00

13-11-29

Qty

Reject

Accept

Qty

DAS 9-89

Insp.

Stamp

150

Quality Control

Memo

0.00

155

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

inspect fit of lid with base

157

Chemical Conversion Coat per QSI005 4.1

0.00

157

HandFinish

Memo

0.00

Hand Finishing

1- realodine corners

do not acid etch

DAS

J 13-11-29

1. 78 13-12.3

DQA:			Date:			,								
QA Closed:		1	Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		lark Ordan	odata anki. T		AEROSPACE
QA Closed:		-	Date:		7		_			V\	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		:
	-					Rework			Skid-tube	Crosstube	7	Water Jet	\neg	Engineering
Part N	lo					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	┨	Quality
	_					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging		Other
NCR N	No					Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desci	ription of work order update	ı	nitial	Actio	on	Sign &		Т	
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		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	et [Temperature/Cure
	(Crimp/Kin	ık/Ripple	/Wave		Burrs .		Inspect	ion Incomplete/Und	Part Lost/Mi	ssing		Weld	
	Щ	Cuffs				Contamination	├			nclear	Part Moved			Wrong Stock Pulled
	Ш'	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong _	_	
		Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	_],	Other
		Inspection	n Strip in	Tube	L	Drawing		Misread	t					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning So	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	oe		Fit/Function	Out of Sequence							

Work Ord		04497		*10	4497*					Page 4
Item ID: Revision ID:	D3915-041			Accept	*N900040	100	* s	Setup Sta	art *	NS1*
Item Name:	Light Lid As	semby, Long Basket						St	op 🛧	NS2*
Start Date:	7/10/13	Start Qty: 1.00	*1*		Cust Item ID:					
Required Date	: 7/12/13	Req'd Qty: 1.00	*1*		Customer:					
Reference:	·	E2					F	Run Sta	art ★ Ⅰ	NID4*
Approvals:	Process Pl	lan:	Date:	_ Tooling:	Date:				op	NR1*
	QC:		Date:	_ SPC (Y/N):	Date:			50	^{°°} *	NR2*
Sequence ID/ Work Center I	D	Operation Description White Gloss (Ref. 4.3.5.1)	Me Juna	Set Up/ Set Up/ Run Device	Tool ID Tool #	Plan Code	Accept Qty	Reject Qty	Rejec Numb	
*160 * Powdercoat C	hy mit	Memo	· ·	0.00	e					d Al
Powder Cating) / '		corner with alodine only s prior to	P	simer: 126873					1 2-12-5
el LL		IST COAT: START TIM OVEN TEX	yé: ipera/ture:	<u> </u>	Paint: 127674					
be fore	sente.	2ND ÇOAT START TIN	********* 2nd coat if no :/ 4E:	·	*****					
		OVEN TEX FINISH TA	MPERATURE: ME:		·					
*170	,)	3-Inspect Part Finish	1	0.00			/			MM 13.12.
QC C		Memo		0.00						71

Quality Control

DQA:			Date:				NON-CONFORMANCE / UPDATE								
QA Closed:		1	Date:			WORK ORDER NON-	-CC	ONFOR	RMANCE / U		Wο	rk Order up	odate only	\neg	AEROSPACE
<u> </u>						DISPOSITION						· · · · · · · ·			
Work Orde	er:					DISPOSITION		•		AGAINST	JEF	PARTMENT	PROCESS		
	_				_	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	۱o					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
		•				Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
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	\square	Centre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	<u> </u>	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re]		Part Incorre	ct	_	Temperature/Cure
	$\bigsqcup_{}$	Crimp/Kin	ık/Ripple	/Wave	<u> </u>	Burrs	Inspection Incomplete/Unqualified					Part Lost/Mi	ssing	<u></u>	Weld
		Cuffs			<u> </u>	Contamination	Instructions Incomplete/Unclear					Part Moved		$ldsymbol{f eta}$	Wrong Stock Pulled
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	Ш	Heat Trea	t			Cut Too Short	Mislabeled Power Loss/Sur					Surge	<u></u>	Other	
	-	Inspection		Tube		Drawing	Misread								
	Ш	Marks/Ch	atter			Drill Holes	Off-set								
		Turning S	equence			Finish		Out of 0	Calibration						
		Wave/Tw	ist in Tub	oe		Fit/Function	Out of Sequence								

Work Orde <i>July-12-13 10:0</i>		4497		*104	149	7*							Page 5
Revision ID:	D3915-041	emby, Long Basket		Accept	*N	1900	040	100)*	Setup	Start Stop	*N:	S1* S2*
	7/10/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	Cust Item ID: Customer:					·			IV.	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):			ate:]	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II)	Operation Description Assemble as per dwg		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
180 HandFinish Hand Finishing	c c	Memo 1- Install we	bbing as per dwg	0.00	e e						4		13/12/
¹⁹⁰		2- Install pla	ecard and label as per dwg	0.00 S	2				J				
QC Quality Control		Memo		0.00	¢							•	

0.00

0.00

Identify as per dwg & Stock Location:

Memo

200

200 Packaging

Packaging

124030-043/13106739 1x & Mistelog

DQA:			Date:			MODI ODDED MON	NON-CONFORMANCE / UPDATE								
QA Closed:		1	Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Wo	ork Order up	odate only	\neg	AEROSPACE
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Work Orde	er:					<i>Dis</i> F03111014				AGAINST	<i>D</i> L	PARTIVILIVI)	PROCESS _		
						Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	۱o					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
		1				Use-as-is			noforming	Finishing		Rec/Stor	e/Packaging	_	Other
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		_	equence			Finish	_	4	Calibration						
	L w	ave/Tw	ist in Tub	e		Fit/Function	L	Out of	Sequence						

Work Orde July-12-13 10:0		04497				Page 6							
Item ID: Revision ID: Item Name:	D3915-04	l Assemby, Long Basket		Accept	*N900	040	100)* 5	Setup	Start Stop	ı VI.	S1* S2*	
Start Date: Required Date: Reference:	7/10/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:				10.				
Approvals:	Process I	Plan:	Date:	Tooling: SPC (Y/N):	D:]	Run	Start Stop	*N *N	R1* R2*			
Sequence ID/ Work Center II 210	D	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp	
QC		Memo		0.00				-47	//				

Quality Control

MIT 12-06

DQA:		Date:			W00W 00050 W0W	ER NON-CONFORMANCE / UPDATE							
QA Closed:	•	Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		Vork Order u	odate only	AEROSPACE	
Work Orde	r·			·	DISPOSITION					EPARTMENT	·		
Part N					Rework Scrap		I	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	0				Use-as-is Suspected Unapproved		mem	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other	
Root				Desci	ription of work order update	П	Initial	Act	tion	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector	
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Supplier													
Training													
Transport													
Unapproved													
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Landin	g Gear				General		_						
	Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced	
L	Centre N	ot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Temperature/Cure	
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled	
	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_	
Heat Treat				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other		
L	Inspectio	n Strip in	Tube		Drawing		Misread	d	_				
	Marks/Cl	natter			Drill Holes		Off-set						
	Turning S	equence			Finish		Out of 0	Calibration					
	Wave/Twist in Tube				Fit/Function	Out of Sequence							

Picklist Print

July-12-13 10:04:35 AM

Work Order ID:

104497

Parent Item:

D3915-041

Parent Item Name:

Light Lid Assemby, Long Basket

Start Date: 7/10/13

Required Date: 7/12/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

10.04.20 verified by:EC

IPP Rev:C add realodine DD 10.04.26 verified by:EC

IPP Rev:B as per dwg revB DD

IPP Rev:E 13.07.08 as per dwg rev.D Rev:D as per dwg revC DD 10.08.18 verified by:EC

DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957 Mounting Plate		Manufactured	No		<u> </u>	100	Each	15.0000	4 B/	03.59		4 ₁	
				<u>Location</u>		Loc Oty	<u>L</u>	oc Code			0AS 43 8-89	13-11	1-27
				WA004		15				<u></u>	68-83	, 3 ,,	ω <i>(</i>
,				848 941		2 5							
¢.				942		8			_:	·		•	
D3915-1 Říb		Manufactured	No	¢		100	Each	13.0000	2 B	94452	رَ 🗻	x	
				Location		Loc Qty	<u>L</u>	oc Code			#DA	512-	11.27
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				940)22	2					, 0 -0	,	
				WA005		1							
				881	.52	1							
				WA006 ' 944	150	10 10			•	 			
D4016-5 Hinge Half, Light Lid		Manufactured	No	94-	132	100	Each	11.0000	3 B.10	3 3557	7 -> -	3 _X	
				Location		Loc Qty	<u>L</u>	oc Code			Q/	Jr	11.27
				WA		11					4.	312-	11.27
				942	271	11					•		
D4019-3 Rib		Manufactured	No			100	Each	19.0000	3 B	94114	→ 2) ₈	DAS 43	13-11-2
				Location		Loc Qty	<u>L</u>	oc Code	BS	4613	→/x	0.89	
				WA006		19				····			
				94		10							
				94	114	9							

DQA:	A: Date:					WORK ORDER NON-	`DART						
QA Closed:		ı	Date:			——	AEROSPACE						
Work Orde		:				DISPOSITION		l					
WOIR OIGE						Rework			Skid-tube C	Crosstube	7	Water Jet	Engineering
Part N	lo.	:				Scrap	Machining Small Fab				Pro	d. Eng. Coor.	Quality
						Use-as-is		Thermoforming Finishing				re/Packaging	Other
NCR N	۱o. <u> </u>			.		Suspected Unapproved			Large Fab Co	omposite]	Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
Design													
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Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
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<u>-</u>							FA	ULT CAT	regory				····
Landi	ng Gear				_	General		1		_	_	_	7
		ding			ļ	Bend			rogram	Ŀ	Outside Dim		Pressure/Forced
	Centre Not Concentric				ļ	BOM/Route		Grain		<u> </u> _	Over/Under	tolerance	Set-up
	Cracks				<u> </u>	Broken/Damage/Defect		Hardwa			Part Incorre		Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs	<u> </u>	Inspect	ion Incomplete/Unqua	alified	Part Lost/M	issing	Weld
	Cuffs				_	Contamination		ł	ions Incomplete/Uncle	ear	Part Moved	L.	Wrong Stock Pulled
	Crushing				<u> </u>	Countersink		1	ned/off center		Positioned V		7
	Heat Treat					Cut Too Short	L.,	Mislabe			Power Loss/	Surge	Other
			Strip in	Tube	lacksquare	Drawing		Misread	i				
	_	rks/Ch				Drill Holes		Off-set					
		_	equence			Finish		Out of (Calibration				
	Wave/Twist in Tube				i	Fit/Function	1	Out of	Seguence				

Picklist Print
July-12-13 10:04:35 AM

Work Order ID: Parent Item:	104497 D3915-041						Start D	Pate: 7/10/13		Daguirad	Date: 7/12	/13
Parent Item Name:		Long Rasket						Qty: 1.00		-	Qty: 1.00	
D4029-041 WEBBING (LONG BA	-	Manufactured Manufactured	No		180	Each	5.0000	1	1	104	794	DAS 32
W PRODUCE (POLICE PLA	o			Location	Loc Qty	•	Loc Code					9-8 9
· 				ST489	5							
1				94089	5							
Lid Rib Assembly Fyld	Light)	Manufactured	_No_		100	Each	10.0000	1	1			
				Location	Loc Qty		Loc Code					
	/4			WA005	10			•				
1-2				94491	10					4	1	
D4035-047		Manufactured	No		100	Each	1.0000	a	2	. 7		
Lid Rib Assembly, Aft	(Light)	(•				Æ1	B_10	7.76	7 ->	Dy	
\$				Location	Loc Qty		Loc Code			045 43		_
		*		WA005	1	¢				43	13-1	1-9ž
		*		87406	1	,				0-83		
D4056-1 Label Plate		Manufactured	No		100	Each	20.0000	1 15-8	50/e	0AS 43	13-11	.J7
į.				Location	Loc Qty		Loc Code			S-83		
				WA004	20							
N \$				85016	17							
•		•		87247	3	,					Das 32	
MS20600-AD4W4 Rivets		Purchased	No		180	Each	6,524.0000	34	34		9-89	· · · · · · · · · · · · · · · · · · ·
				Location	Loc Qty		Loc Code				•	
				ST	5000.			1	266	\sim		*
				125577	5000			N) / e	200	2)		
				ST311	374							
				123900								
				125406	5 24							
				ST506	1150							
A STATE OF THE STA				125654	1150							
· .												

DQA:	A: Date:					WORK ORDER NON	DART						
QA Closed:		i.	Date:			WORK ORDER NON-	AEROSPACE						
						DISPOSITION							
Work Orde	er: —						,				1		,
Down N	1.					Rework	Skid-tube Crosstube					Water Jet	Engineering
Part N			-			Scrap Use-as-is		Machining Small Fab Thermoforming Finishing			1	d. Eng. Coor.	Quality
NCR N	do					Suspected Unapproved		mern	- - - -	Finishing Composite	Rec/Stor	re/Packaging	Other
WCK	···	•				Juspected Ollappioved	1		raige rab	Composite		Supplier	ا لـا
Root					Desci	ription of work order update		nitial	Actio	n	Sign &		
Cause	(Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	_												
Handling/Pre									1				
Material													
Operator													
Offset/Setup		2	E.				1						
Process		•											
Supplier	_						1						
Training	_						ŀ						
Transport	_												
Unapproved									<u> </u>	- · · -			<u> </u>
							FAI	ULT CAT	TEGORY				· · · · · · · · · · · · · · · · · · ·
Landir	ng Gea					General					,		_
		nding			<u> </u>	Bend		1	Program		Outside Dim	ensions	Pressure/Forced
	Centre Not Concentric			ntric		BOM/Route	$oxed{oxed}$	Grain		<u> </u>	Over/Under	tolerance	Set-up
ļ	Cracks				<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa	are	<u> </u>	Part Incorred	ct	Temperature/Cure
	Crimp/Kink/Ripple/Wave				<u> </u>	Burrs		Inspect	ion Incomplete/Unqu	ualified	Part Lost/Mi	ssing	Weld
	Cuffs				\perp	Contamination		4	tions Incomplete/Und	clear	Part Moved		Wrong Stock Pulled
	Crushing					Countersink		Misalig	gned/off center		Positioned V	Vrong	_
	Heat Treat					Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	_		n Strip in	Tube		Drawing		Misread	d				
	Ма	arks/Ch	atter			Drill Holes		Off-set					
	Tu	rning S	equence			Finish		Out of (Calibration				
	Wave/Twist in Tube					Fit/Function		Out of	Sequence				

Picklist Print

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Work Order ID:

104497

Parent Item:

D3915-041

Parent Item Name:

Light Lid Assemby, Long Basket

NAS1149DN949J Washer

Purchased

No

Start Date: 7/10/13

Required Date: 7/12/13

Start Qty: 1.00

Required Qty: 1.00

34

Location ST293

120833

Loc Oty 31 31 Each

180

Loc Code

31.0000

DQA:		Date:														
					WORK ORDER NON-CONFORMANCE / UPDATE											
QA Closed:		Date:							W	ork Order up	odate only	<u> </u>				
Work Orde	or.				DISPOSITION	DISPOSITION AGAINST DEPARTMENT/PROCESS										
Work Orde	···	- i	•	-	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering				
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality				
				_	Use-as-is			noforming	Finishing	-	re/Packaging	Other				
NCR N	lo.				Suspected Unapproved			Large Fab	Composite	1	Supplier	1				
						•				-						
Root				Descr	ription of work order update	ĺ	nitial	Actio	on	Sign &						
Cause	Date	e Step	Qty		or non-conformance	Ch	ief Eng	Descrip	ption	Date	Verification	QC Inspector				
Design																
Doc/Data																
Equip/Tooling																
Handling/Pre																
Material																
Operator																
Offset/Setup																
Process																
Supplier																
Training																
Transport	_					1										
Unapproved			11			<u> </u>										
		-t				FAI	ULT CA	TEGORY								
Landir	ng Gear				General	_	1					-				
-	Bendir	-		_	Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced				
	Centre	Not Conce	ntric		BOM/Route	L	Grain			Over/Under	tolerance	Set-up				
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temperature/Cure				
		/Kink/Ripple	e/Wave		Burrs	L	Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld				
	Cuffs				Contamination		4	tions Incomplete/Ur	nclear	Part Moved		Wrong Stock Pulled				
	Crushi	_			Countersink		1	gned/off center		Positioned V	<u> </u>	-				
ļ	Heat T				Cut Too Short		Mislab	eled		Power Loss/	Surge	Other				
ļ		tion Strip in	Tube	<u> </u>	Drawing	<u></u>	Misrea	d								
	Marks	/Chatter			Drill Holes		Off-set									
	Turnin	g Sequence	•		Finish	L_	Out of	Calibration								
ŀ	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence								

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

QTY -041 ITEM DESCRIPTION X D3915-041 LIGHT LID ASSY, LONG BASKET ASSY BASKET LID WELDMENT ASSY D3915-101 DART LOGO LABEL 2 D2728-1 3 D4029-041 WEBBING (LONG BASKET) 4 34 NAS1149DN949J WASHER 5 34 MS20600AD4W4 RIVET, BLIND, PAN-HEAD C8-3 D4035-047 WAS D4035-045 (REASON PROPARM OPTION REMOVED). SHT 3 DETAIL C DELETED FOR DRAWING CLARITY.

MS20600AD4WA WAS MS20600AD4W3; NAS1149DN849J WAS NAS1149DN416J (ZN D6-1, C6-1, B1-2).

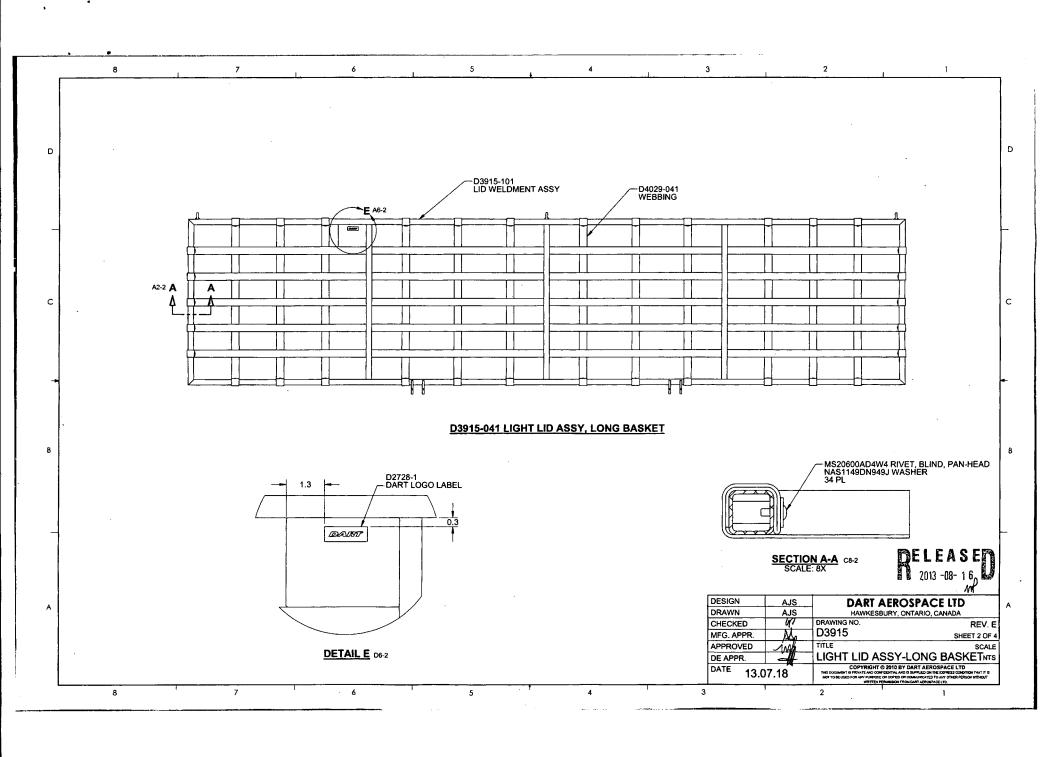
REASON: PAR13-259. AJS 13.07.18 13.06.19 REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3), REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-22), UPDATED VIEW E ACCORDINGLY (A6-2), REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A. С MB 10.08.05 MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2) JPH 10.04.06 D3915-041 LIGHT LID ASSY, LONG BASKET ASSY NEW ISSUE JPH 10.03.16 REV. DESCRIPTION BY DATE

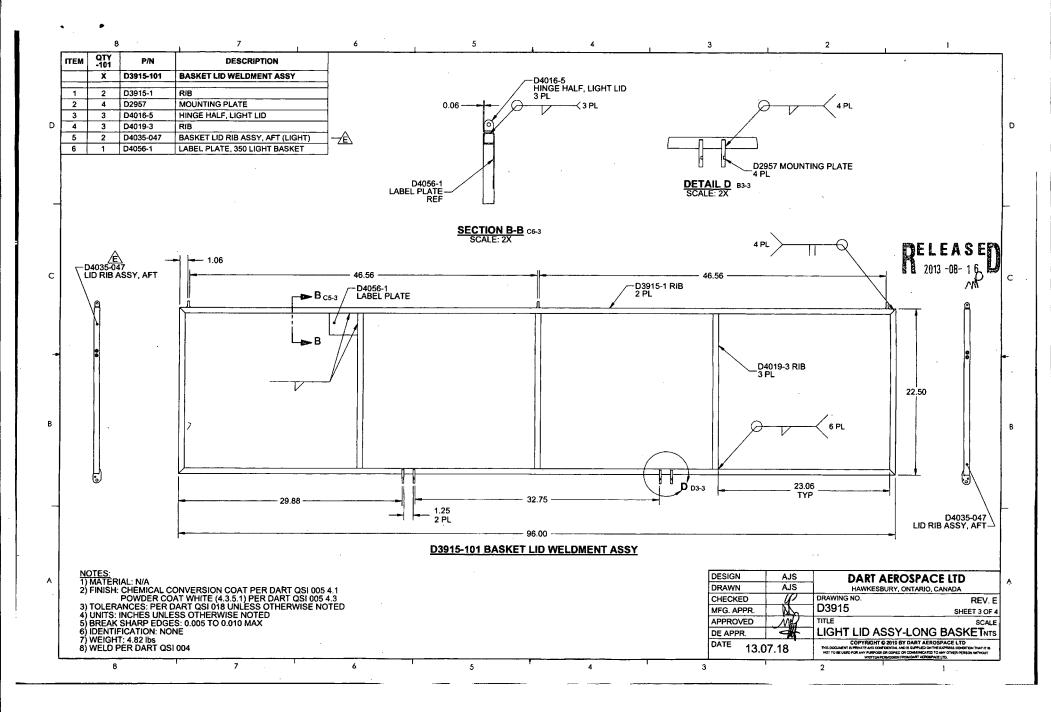
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A

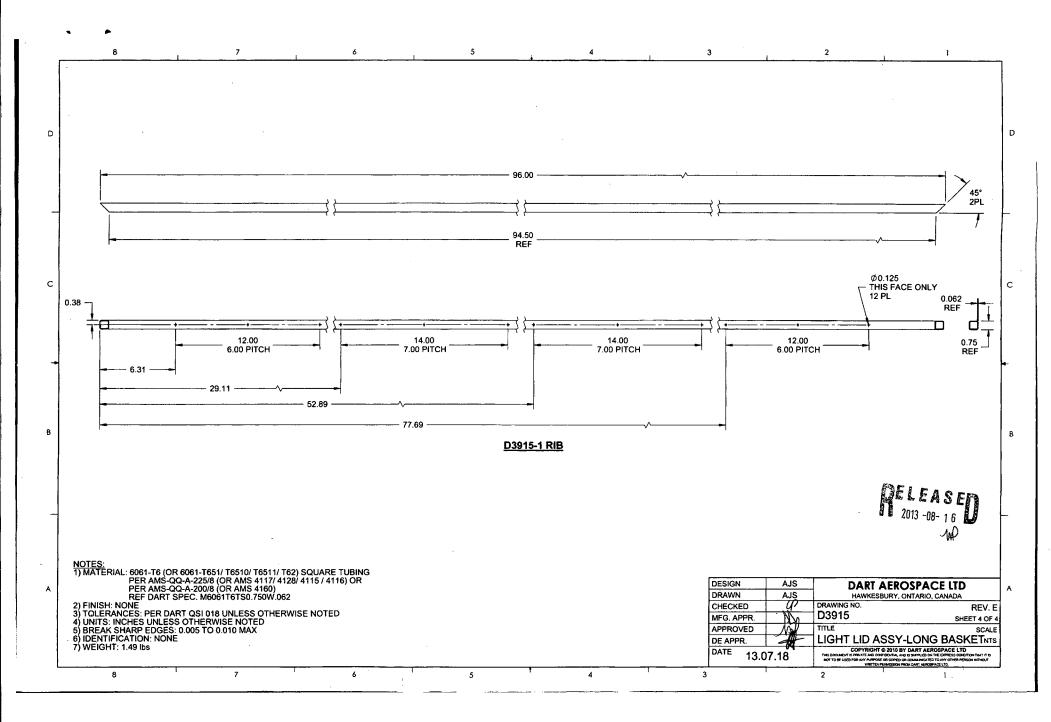
6) IDENTIFICATION: NONE 7) WEIGHT: 6.98 lbs

DESIGN	AJS	DART AEROSPACE LTD								
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA								
CHECKED	UP	DRAWING NO.		REV. E						
MFG. APPR.	34	D3915	SHEET 1 OF 4							
APPROVED	w	TITLE		SCALE						
DE APPR.	-#	LIGHT LID ASSY-LO	ONG BASKETNTS							
DATE 13.0	07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOQUERT IS PRIMATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PROPOSE OR CONSUMENTED TO ANY OTHER PESSON WITHOUT								

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